								DQA:	Date:			
NCR: Yes	s / No			WORK ORDER NON-	CONFO	RMANCE / U	JPDATE	QA Closed:	Date:			
Nork Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.				 Rework Scrap Use-as-is Work Order Update] 	Skid-tube Crosstu Machining Small F Thermoforming Finishi Large Fab Composi		⊣	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root Cause	Date	Step	Qty	iption of work order update or Non-conformance	Initia Chief E		Action escription	Sign & Date	Verification	QC Inspector		
quip/Tooling perator Material etup Other Process upplier Fraining												
 				F	AULT CA	TEGORY						
Landing	Gear			 General	AUC! Cr	TEGORI				1		
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Insp Inst Mai Misl Offs	dware ection Incomplete ructions Incomple intenance abeled read	F	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

NCR: '	Yes / No)			WORK ORDER NON-O	CONI	FORM	MANCE / UPI	DATE				
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Work Orde	er:		_	" 	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part I					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Sto	Engineering Quality Other		
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Root	ł			1	ption of work order update	1	itial		tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector	
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Operator		İ				Ì							
Material		-	}										
Setup	 											j	
Other		-		[
Process	\vdash												
Supplier	\vdash			}				}		}		1	
Training 	H			1								1	
Unapproved	<u> </u>		<u> </u>	1		AULT	CATE	L GORY				<u>.l</u>	
	ng Gear			-	General General	AULI	CATE	GONT					
Canut	Bendin			Г	Bend	По	irain		۲-	Ovalized	ſ	Pressure/Forced	
	⊢ ∹	ಕ Not Conce	ntric to	o/s	BOM/Route		lardwa	ıre	-	Over/Under	tolerance	Temperature/Cure	
	Cracks	Wot Conte		°'	Broken/Damaged	 -		ion Incomplete	-	Part Incorre	<u> </u>	Weld	
	⊢	d/Crimped	!	⊢	Burrs	├ ──	•	tions Incomplete/	Unclear	Part Lost/Mi	⊢	Wrong Stock Pulled	
	Cuffs	a, ci iiipeo		<u> </u>	Contamination			enance		Part Moved			
	Heat T	reat		-	Countersink	\vdash	/lislabe		 	Positioned V	Vrong		
	├ ─-	tion Strip in	n Tube	-	Cut Too Short	$\boldsymbol{\vdash}$	/lisread			Power Loss/		Other	
	} - 1	in Bend	••	-	Drill Holes		Offset		<u>L.</u>	1	- L	<u></u>	
	\vdash	Waves in	Extrusio	n	Drawing	\mathbf{H}		Calibration					
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Outside Dimensions

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Wave/Twist in Tube

Folio

•								nan i		
- Work Ordo May-27-13 12:-		2156		*102	2156*					Page 3
tem ID: Revision ID: Item Name:	D2274 Radius Block		* T.J. & T.E. ~ * * * * * * * * * * * * * * * *	Accept	*N900)04010	ገበ*	Setup Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	5/16/13 : 6/07/13	Start Qty: 280.00 Req'd Qty: 280.00	*28(*28(Cust Item Customer:					
Approvals:		n:			-	Date:		Run Start Stop	[7]	R1* R2*
Sequence ID/ Work Center II 160 *160*	D	Operation Description QC7-Inspect Chemical C	onversion Coat	Set Up/ Run Hours 0.00	Tool ID	Tool # Pla			Reject Number	Insp. Stamp
QC Quality Control		Memo		0.00		S)ON (-7	(J) / 11/		3708/1
¹⁷⁰ *17∩*		Identify as per dwg & Sto	ock Location: <u>STC</u>				321	1 - M.A	Q. 13	-08-14
Packaging Packaging		Memo		0.00				(
¹⁸⁰ *1ጸ∩*		QC21- Final Inspection -	Work Order Release	0.00	\		4	115 12-	08-16)
QC Quality Control		Memo		0.00	\ \ i		C_{ρ}	13.8-10	5	1

NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	AANCE / UP	DATE			
										QA Closed:	Date:	
Work Orde	s i.				DISPOSITION	1			AGAINST DE	PARTMENT/	PROCESS	
WOIN OIGE					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1	ľ	Machining	Small Fab	Proc	d. Eng. Coor.	Quality
					Use-as-is] т	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo.				Work Order Update] [Large Fab	Composite]	Supplier	
		Τ.	1 1		<u> </u>			c: 0				
Root	D-1-	54	0		ption of work order update	Init		Act		Sign & Date	Verification	QC Inspector
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descr	iption	Date	vermeation	QC Inspector
Doc/Data			ľ									•
Equip/Tooling		1										
Operator Material		[
Material Setup		1				1						
Other										1 1		
Process						1				}		•
Supplier												
Training						1						
Unapproved										_[]		
		_	<u> </u>		F	AULT (CATE	GORY				
Landir	ng Gear				General							_
	Bending				Bend	G	rain			Ovalized .		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s [BOM/Route	На	ardwa	re		Over/Under	tolerance	Temperature/Cure
. 1	Cracks				Broken/Damaged	ln:	specti	on Incomplete		Part Incorrec	t	Weld
	Crushed	/Crimped			Burrs	ln:	struct	ions Incomplete/U	Jnclear	Part Lost/Mis	ssing	Wrong Stock Pulled
	Cuffs			L	Contamination	Шм	lainte	nance	_	Part Moved		
	Heat Tre	at			Countersink	Шм	lislabe	led	_	Positioned W	· -	1
	inspection	on Strip in	Tube		Cut Too Short	-	lisreac	I		Power Loss/S	Surge	Other
	Ripples i	n Bend		<u> </u>	Drill Holes		ffset					
	Torque \	Waves in I	Extrusio	ո	Drawing	100	ut of (Calibration				
	Turning :	Sequence	:	1	Finish	[O	ut of S	Sequence				

Outside Dimensions

Date:

Wave/Twist in Tube

Folio

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Work Order ID:

102156

Parent Item:

D2274

Parent Item Name:

Radius Block

Start Date: 5/16/13

Required Date: 6/07/13

Start Qty: 280.00

0.0916

Required Qty: 280.00

Comments:

IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name

Replacement Item ID

Mfg/ Purch

Purchased

Bin Item

No

Last **Primary** Location Location

Route Seq ID Unit of

Qty on Measure Hand

Qty per Kit Total Qty

Qty Date Issued Issued

Status

Page 1

M6061T6B00750X00.125

6061-T6 Bar .750 x .125

0.0000

26.997908

			υų
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

NCR: Y														
						_					QA Closed:	Date	: 	
Nork Orde	er:					DISPOSITION				AGAINST DE	DEPARTMENT/PROCESS			
Part N	lo.					Rework Scrap				Crosstube Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR N	lo.					Use-as-is Work Order Update		Thermoforming Finishing Large Fab Composite			Rec/Stor	e/Packaging Supplier	Other	
Root					Descri	iption of work order update		nitial	Act	ion	Sign &			
Cause	•	Date	Step	Qty	_	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
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quip/Tooling														
perator												ı		
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						F	AUL	T CATE	GORY					
Landii	ng (Gear				General		_			_		_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
•		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
•		Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorred	rt	Weld	
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved		_	
		Heat Trea	it			Countersink		Mislabe	leđ	Γ	Positioned V	Vrong		
		Inspection	n Strip in	<u> </u>			Misread	1	Г	Power Loss/:	Surge	Other		
		Ripples in				Drill Holes		Offset		<u>. </u>	- 			
		Torque W		xtrusio	n	Drawing		Out of 0	Calibration					
		Turning S				Finish		Out of S	Sequence					
	Г	Wave/Tw			·	Folio		Outside Dimensions						

Date:

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DART AEROSPACE LTD	Work Order:	102126
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	.258			MHOY	Caliper
0.750	+/-0.010	,753	J			
0.375	+/-0.010	-375				
0.125	+/-0.010	130	1			
0.750	+/-0.010	- 752	1			
0.063	+/-0.010	. 028	/			
			-			
						,
	 	 _	<u></u>			
						
			 			
	 					
	l					}

Measured by: MH Jord	Audited by:	Prototype Approval:	N/A
Date: 13/07/20	Date: 13-1-22	Date:	N/A

ĺ	Rev	Date	Change	Revised by	Approved
Ĭ	Α	03.10.07	New Issue	KJ/RF	17
•				······································	

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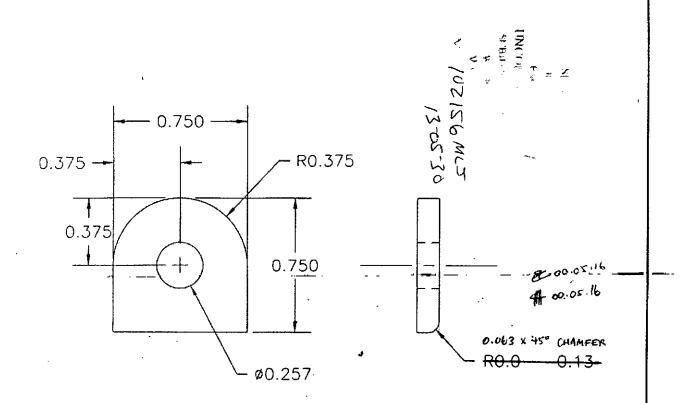
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	DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECH	ED /	APPROVED	DRAWING NO. REV	F
)	1		14	D2274 SHEET 1 OF	F 1
	DATE		7	TITLE SC	ALE.
	98.0	8.11		RADIUS BLOCK	2:1
	Α		94.09.29	NEW ISSUE	
	С		95.07.12	RADIUS ENDS	
	D		97.03.24	ADD MATERIAL SPECIFICATION	
	Ε		97.12.12	ADD FINISH & TOLERANCE QSI	
	F		98.08.11	RO.O - 0.13 WAS RO.063 - 0.125	

RELEASED 18/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

